

Date: Wednesday, 13/08/2008 10:54:52 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BRACKET ASSEMBLY
Job Number :	41199		
Estimate Number :	10420		
P.O. Number :		Part Number :	D3303043
This Issue :	13/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3303 REV. B
First Issue :	//	Project Number :	N/A
Previous Run :	40906	Drawing Revision :	B
	Type :	Material :	
	SMALL /MED FAB	Due Date :	27/08/2008
Written By :		Qty:	30 Um: Each
Checked & Approved By :	JUL 08.8.13		
Comment :	Est: A 04.09.07 New Issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33031	Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

PLATE

Pick:

Qty	Part Number	Description
1	D3303-1	Plate

Batch

B40942

B 38971

2.0	D33033	Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

BRACKET

Pick:

Qty	Part Number	Description
1	D3303-3	Bracket

Batch

B40943

3.0	MS20426AD33	Rivet
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 240.0000 Each(s)

RIVET

Pick:

Qty	Part Number	Description
8	MS20426AD3-3	Rivet

Batch

M1503

4.0	MS20470AD44	Rivet, Universal Head
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 480.0000 Each(s)

Rivet, Universal Head

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 13/08/2008 10:54:52 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 41199

Part Number: D3303043

Job Number:



Seq. #:

Machine Or Operation:

Description :

16 MS20470AD4-4 Rivet

M107823

5.0

MS21075L3

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total: 120.0000 Each(s)

Nutplate

Pick:

Qty Part Number

Description

Batch

4 MS21075L3

Nut Plate

M108751 (12x)

M108940 (108)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D3303

2- Identify as D3303-043

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

****MASK THREADS PRIOR TO PAINT****

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:10
320 OF
9:40

M-L 08/08/26

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-08-26

30

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 188

8/8/26

54

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 13/08/2008 10:54:52 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 41199

Part Number: D3303043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/27/08

Job Completion



mf 08-0826

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

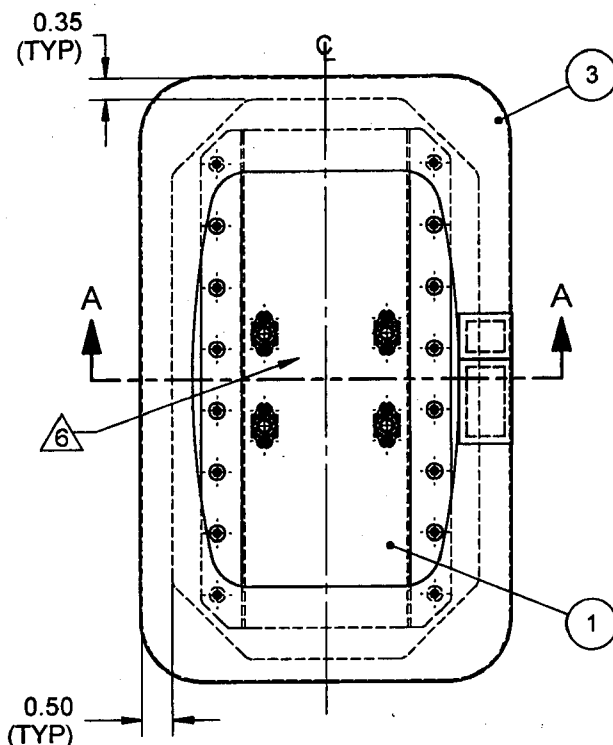
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

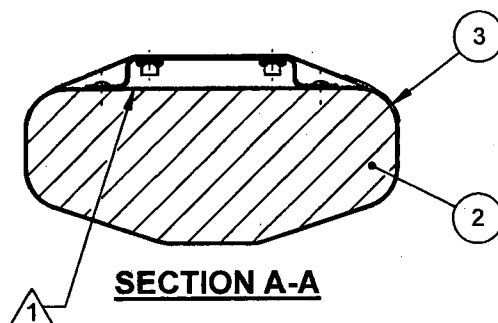


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 1 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:3
REV	DATE	DESCRIPTION	
A	04.08.18	NEW ISSUE	
B	06.08.17	UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE	



RELEASED

dc 09.19 *[Signature]*



D3303-041 HEAD REST

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

NOTES:

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACORDDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

SHOP COPY
RETURN TO

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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

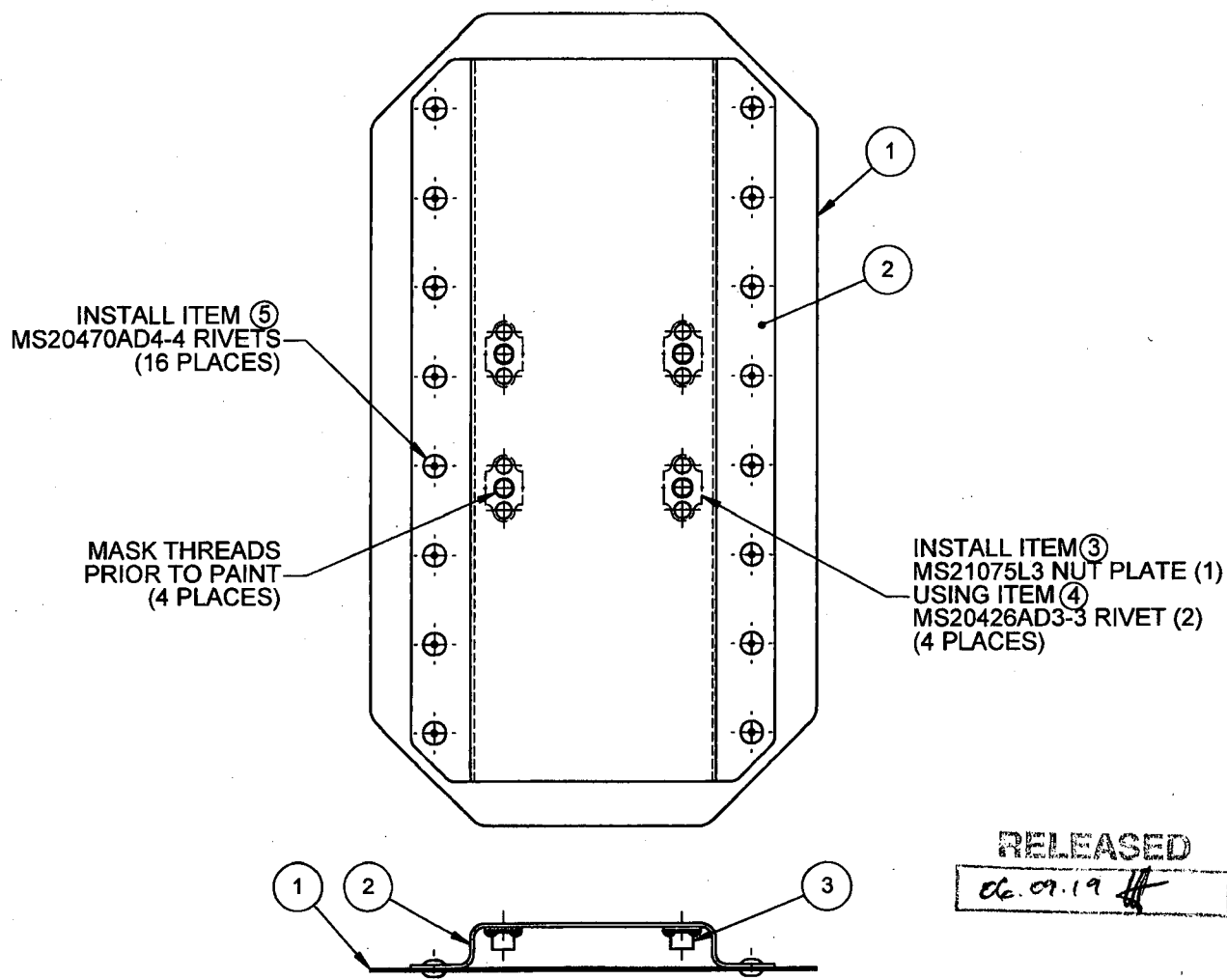
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 2 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2

**RELEASED***06.09.19***D3303-043 BRACKET ASSEMBLY**

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

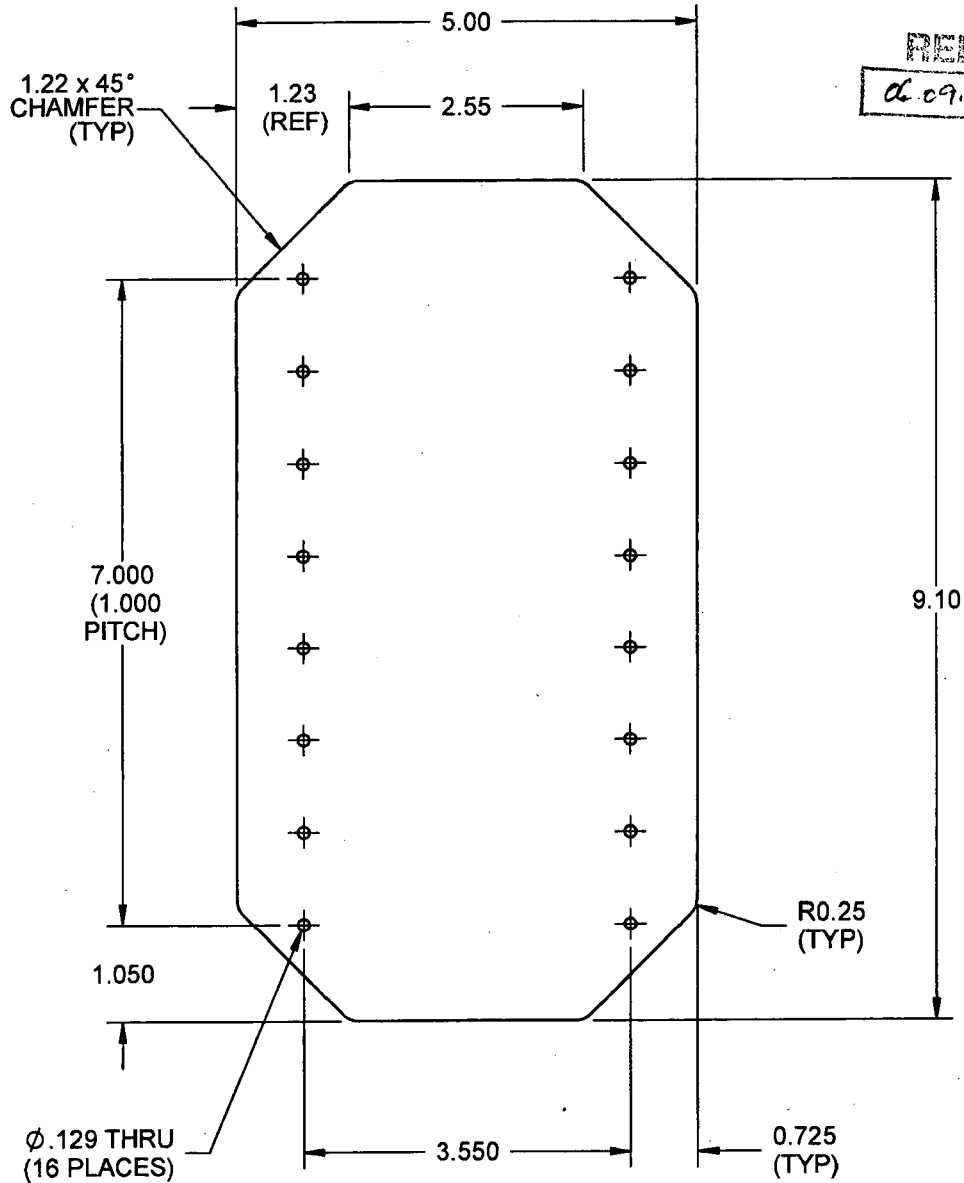
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 3 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2

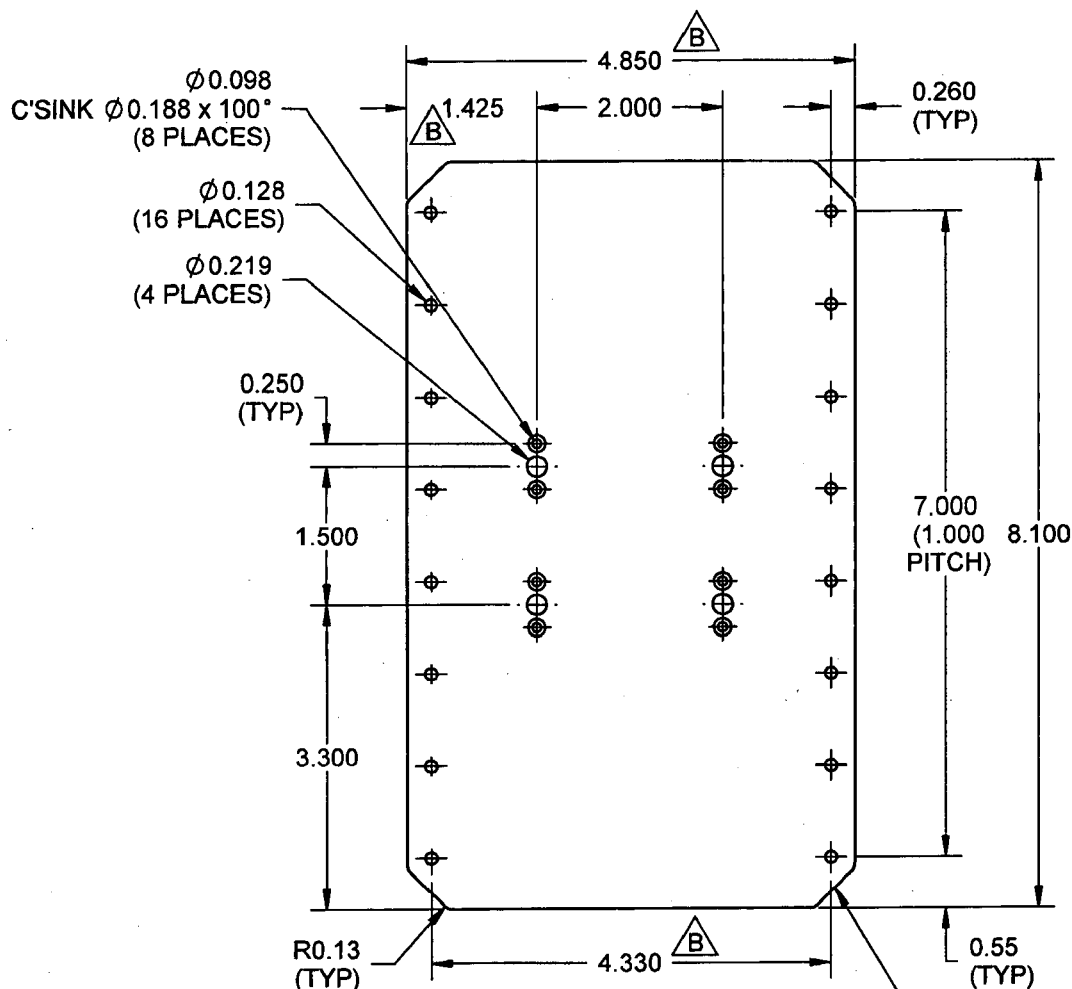
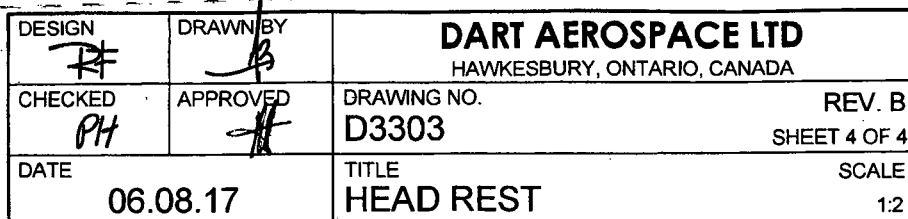
**D3303-1 PLATE****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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NO. *91197*

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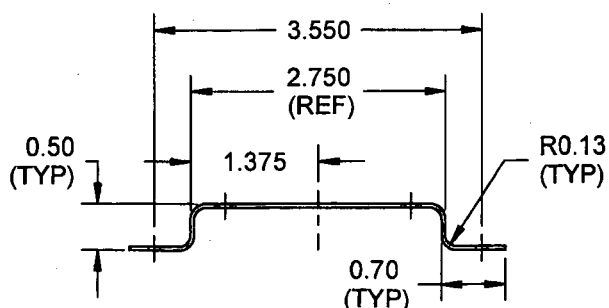


SECRET

6-69.19

D3303-3F BRACKET FLAT PATTERN

0.55
(TYP) SHOP COPY
RETURN TO
0.44 x 45° ENGINEERING
-CHAMFER UNCONTROLLED COPY
(TYP) SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41199



D3303-3 BRACKET BEND DETAIL

NOTES:

- NOTES:**
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET
(REF. DART SPEC. M2024T3S.040)
 - 2) FINISH: CHEMICAL CONVERSION COAT AS PER
DART QSI 005.4.1
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE
NOTED
 - 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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